

Friday, 5/10/2007 2:35:45 PM
Johnston

Process Sheet

CU-DAR001 Dart Helicopters Services	Drawing Name	: INNER FWD SADDLE
: 32301		
Estimate Number : 11079	Part Number	: D5953
P.O. Number : N/A	Drawing Number	: D5953 REVB
This Issue : 5/10/2007	Project Number	: N/A
Prsht Rev. : NC	Drawing Revision	: B
First Issue : N/A	Material	: N/A
Previous Run : 31529	Due Date	: 6/5/2007
Written By : <u> </u>	Qty:	14 Um: Each
Checked & Approved By : <u> </u>		
Comment : Est Rev:E Re-Format 05-11-29 JLM		
Est Rev:f ecn 826 06.12.06 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	7075-T7351 8.25X7.75X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
D6101-007(7075-T7351)
Size 2.50" x 7.50" X 8.25" (Grain along 7.50")
Batch: 325353

9th 07/06/20 14

2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3
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Comment: HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5953, Ensure Batch Number is entered

2-Machine Keyway

3-Deburr & Tumble

9th 07/06/20 14

3.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

9th 07/06/20 14

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5-L 07/06/25

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

M-L 07/06/25

14x

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: FD Date: 07/06/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/19	2.0	2 part scrap. the finishing tool come loose by the vibration.	<i>[Signature]</i>	change the tool and I put lockite on the screw destroy & replace. verify set-up & tools prior to operation.	<i>[Signature]</i> 07/06/20	<i>[Signature]</i> 07/06/20	<i>[Signature]</i>	<i>[Signature]</i> 07/06/20

NOTE: Date & initial all entries

Date: Thursday, 5/10/2007 2:35:45 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INNER FWD SADDLE

Job Number: 32301

Part Number: D5953

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

POWDER COATING

POWDER COATING



M 124144



(14)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BR / M-107-06-28

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



7/6/27 SQ



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

CU 7/6/27 SQ

(14)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(14)

Comment: FINAL INSPECTION/W/O RELEASE

1-9-07-06-27

Job Completion



1-9-06-27

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	32301
Description: Inner Fwd Saddle		Part Number:	D5953
Inspection Dwg: D5953	Rev: B	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		0.440	0.439	0.439	0.439		
B	1.745	1.755		1.750	1.749	1.750	1.749		
C	5.245	5.255		5.250	5.249	5.250	5.249		
D	6.995	7.005		7.000	6.999	7.000	6.999		
E	5.745	5.755		5.748	5.747	5.748	5.748		
F	4.745	4.755		4.749	4.749	4.748	4.749		
G	0.313	0.318	315-7.322	0.319	0.320	0.320	0.320		
H	1.522	1.532		1.526	1.528	1.525	1.525		
I	3.048	3.058		3.052	3.052	3.053	3.052		
J	4.575	4.585		4.579	4.579	4.579	4.579		
K	0.313	0.318	315-7.322	0.319	0.320	0.320	0.320		
L	0.495	0.505		0.499	0.499	0.499	0.499		
M	0.490	0.510		0.503	0.503	0.503	0.502		
N	1.615	1.635		1.635	1.635	1.635	1.635		
O	7.990	8.010		7.996	7.996	7.998	7.998		
P	2.240	2.260		2.260	2.260	2.260	2.260		
Q	0.307	0.312		0.310	0.310	0.310	0.310		
R	0.760	0.765		0.760	0.760	0.760	0.760		
S	0.490	0.510		0.506	0.502	0.504	0.503		
T	1.375	1.395		1.382	1.382	1.382	1.382		
U	2.000	2.020		2.002	2.001	2.002	2.000		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>[Signature]</i>
Date:	07/06/20

Audited by:	<i>[Signature]</i>
Date:	07/06/25

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.12.06	Dimensions L,N,P revised	KJ/EC	

DART AEROSPACE LTD		Work Order:	32301
Description: Inner Fwd Saddle		Part Number:	D5953
Inspection Dwg: D5953	Rev: B	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		0.439	0.439	0.439	0.439		
B	1.745	1.755		1.749	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.745	5.755		5.747	5.749	5.751	5.748		
F	4.745	4.755		4.748	4.749	4.749	4.748		
G	0.313	0.318	315 → 322	0.320	0.320	0.320	0.320		
H	1.522	1.532		1.525	1.525	1.526	1.525		
I	3.048	3.058		3.053	3.053	3.054	3.053		
J	4.575	4.585		4.579	4.579	4.580	4.580		
K	0.313	0.318	315 → 322	0.320	0.320	0.320	0.320		
L	0.495	0.505		0.499	0.499	0.499	0.499		
M	0.490	0.510		0.503	0.503	0.503	0.503		
N	1.615	1.635		1.635	1.635	1.635	1.632		
O	7.990	8.010		7.997	7.998	7.999	7.999		
P	2.240	2.260		2.260	2.260	2.260	2.260		
Q	0.307	0.312		0.310	0.310	0.310	0.310		
R	0.760	0.765		0.760	0.760	0.760	0.760		
S	0.490	0.510		0.502	0.503	0.502	0.503		
T	1.375	1.395		1.380	1.380	1.385	1.381		
U	2.000	2.020		2.000	2.000	2.002	2.000		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>Amk</i>
Date:	07/06/26

Audited by:	<i>J.L.</i>
Date:	07/06/25

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.12.06	Dimensions L,N,P revised	KJ/EC	

DART AEROSPACE LTD		Work Order:	32301
Description: Inner Fwd Saddle		Part Number:	D5953
Inspection Dwg: D5953	Rev: B	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4 12		
A	0.438	0.443		0.439	0.439	0.439	0.439		
B	1.745	1.755		1.750	1.749	1.749	1.749		
C	5.245	5.255		5.256	5.249	5.248	5.256		
D	6.995	7.005		7.000	7.000	6.999	6.999		
E	5.745	5.755		5.748	5.749	5.748	5.749		
F	4.745	4.755		4.748	4.748	4.748	4.749		
G	0.313	0.318	3.15 → 3.32	0.320	0.320	0.326	0.326		
H	1.522	1.532		1.525	1.525	1.526	1.525		
I	3.048	3.058		3.053	3.053	3.054	3.053		
J	4.575	4.585		4.579	4.579	4.579	4.579		
K	0.313	0.318	3.15 → 3.32	0.326	0.326	0.326	0.326		
L	0.495	0.505		0.499	0.499	0.499	0.499		
M	0.490	0.510		0.503	0.503	0.503	0.503		
N	1.615	1.635		1.633	1.631	1.629	1.628		
O	7.990	8.010		7.997	7.998	7.999	7.999		
P	2.240	2.260		2.260	2.260	2.260	2.260		
Q	0.307	0.312		0.310	0.310	0.310	0.310		
R	0.760	0.765		0.760	0.760	0.760	0.760		
S	0.490	0.510		0.502	0.502	0.502	0.502		
T	1.375	1.395		1.384	1.384	1.384	1.382		
U	2.000	2.020		2.001	2.001	2.000	2.000		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>gml</i>
Date:	07/06/20

Audited by:	<i>JL</i>
Date:	07/06/25

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.12.06	Dimensions L,N,P revised	KJ/EC	

DART AEROSPACE LTD		Work Order: 32301
Description: Inner Fwd Saddle		Part Number: D5953
Inspection Dwg: D5953	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	113	214	3	4		
A	0.438	0.443		435	438				
E	1.745	1.755		1.750	1.751				
C	5.245	5.255		5.257	5.250				
D	6.995	7.005		7.000	7.000				
E	5.745	5.755		5.749	5.748				
F	4.745	4.755		4.749	4.748				
G	0.313	0.318	0.315-0.322	0.320	0.320				
H	1.522	1.532		1.525	1.526				
I	3.048	3.058		3.053	3.052				
J	4.575	4.585		4.579	4.578				
K	0.313	0.318	0.315-0.322	0.320	0.320				
L	0.495	0.505		0.499	0.498				
M	0.490	0.510		0.503	0.503				
N	1.615	1.635		1.630	1.630				
O	7.990	8.010		8.001	8.001				
P	2.240	2.260		2.266	2.260				
Q	0.307	0.312		0.310	0.310				
R	0.760	0.765		0.763	0.763				
S	0.490	0.510		0.500	0.501				
T	1.375	1.395		1.382	1.383				
U	2.000	2.020		2.000	2.001				
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

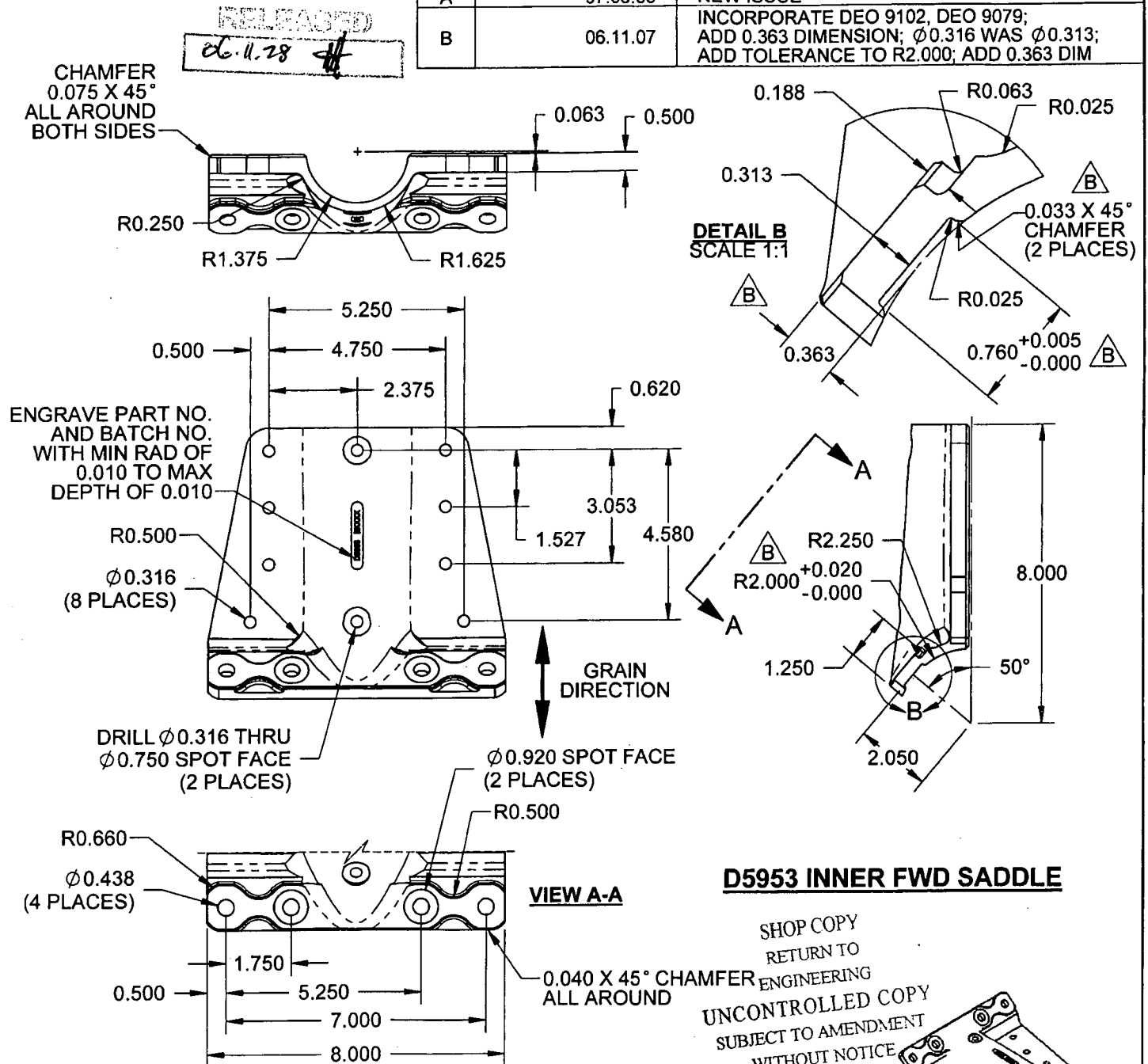
Measured by:	SA
Date:	01.06.21

Audited by:	SL
Date:	07/06/25

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.12.06	Dimensions L,N,P revised	KJ/EC	

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D5953	REV. B SHEET 1 OF 1
DATE 06.11.07	TITLE INNER FWD SADDLE		SCALE 1:4
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE	
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; Ø0.316 WAS Ø0.313; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

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